

5/22

split-B

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23190
<b>Description:</b> Pedal Assembly	<b>Part Number:</b>	D3204-041
<b>Dwg:</b> D3204 Rev. A	<b>Qty:</b>	4
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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Travelers for: D3204-041 Pedal Assembly D3204-1 Tube D3204-7 Bushing Dwg not required Batch 23190 23190 23190	HJ	05.07.6	4
2	MV	Cut blank: 2.00" x 0.50" x 6.520" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.500x02.000) Identify for D3204-3 Batch: M17037	SD	05.07.07	10
3	MV	Cut blank: 1.25" x 0.375" x 3.370" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.375x01.250) Identify for D3204-5 Batch: M7321	SD	05.07.07	10
4	MV	Cut blank: 1.00" x 0.500" x 1.150" long Bar (+0.030/-0.000) Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.500x01.000) Identify for D3204-11 Batch: M10973	SD	05.07.07	10
5	MV	Cut blank: 2.000" x 0.375" x 3.100" long Bar Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) (M6061T6B0.375x02.000) Identify for D3204-9 Batch: M5185	SD	05.07.07	10
6	MV	Machine D3204-3 as per Folio FA344 and Dwg D3204 Identify as D3204-3	SD	05.07.07	10
7	QC2	Inspect parts as they come off the CNC machine	SD	05.07.07	16
8	MV	Deburr	SD	05.07.07	10
9	QC8	Second check	BE	05.07.08	10
10	MV	Machine D3204-5 as per Folio FA344 and Dwg D3204 Identify as D3204-5	SD	05.07.08	10
11	QC2	Inspect parts as they come off the CNC machine	SD	05.07.08	10
12	MV	Deburr	SD	05.07.08	10
13	QC8	Second check	BE	05.07.08	10
14	MV	Machine D3204-11 as per Folio FA357 and Dwg D3204 Identify as D3204-11	SD	05.07.08	10
15	QC2	Inspect parts as they come off the CNC machine	SD	05.07.08	10
16	MV	Deburr	SD	05.07.08	10
17	QC8	Second check	BE	05.07.08	10
18	MV	Machine D3204-9 as per Folio FA357 and Dwg D3204 Identify as D3204-9	BE	05.07.09	10
19	QC2	Inspect parts as they come off the CNC machine	BE	05.07.09	10

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	23190
<b>Description:</b> Pedal Assembly	<b>Part Number:</b>	D3204-041
<b>Dwg:</b> D3204 Rev. A	<b>Qty:</b>	4
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Step	Location	Procedure	By	Date	Qty
20	MV	Deburr	BC	05.07.09	10
21	QC8	Second check	BC	05.07.09	10
22	WA	Cut (2) D3204-13 per Assembly Cut blanks as per Dwg D3204 Material: 6061-T6 (QQ-A-250/11) 0.125" thick (M6061T6S.125) Identify as D3204-13 Batch: M15120 M17695	CPL	05.07.14	10
23	WA	Grind hypotenuse side	CPL	05.07.14	10
24	WA	Weld assembly as per Dwg D3204 using Jig D3204-041T1 Pick: D3204-1 B23190 B23524 Qty Part Number Description 1 D3204-1 Tube Identify as D3204-041 -3 B21783 B23190 -5 B21783 B23190 -9 B21783 B23190 -11 B23190	CPL	05.07.14	10
25	QC5/9	Inspect weld	DA	05/07/14	10
26	FP	Chemical Conversion Coat as per QSI 005 4.1	FF	05.07.14	10
27	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3 D3204-041 Note: Cover holes for bushing	FL	05/07/14	10
28	QC3	Inspect Powder Coat	SD	05/07/15	10
29	GA	Install D3204-7 bushing as shown in Dwg D3204 Pick: Qty Part Number Description Batch 2 D3204-7 Bushing 23928 501782	SB	06-03-15	3
30	QC5	Inspect work to Step 29	SB	05/07/15	10
31	ST	Identify and Stock D3204-041 Qty: 3 D3204-1 Qty: D3204-7 Qty: Note: D3204-1/-7 are stocked in welding cell	DL	06/03/15	3
32	AC	Parts to Stock and Prorate Cost to parts per Step 31 Cost / part 172.62 / 172.62	DL	05/07/15	3
33	DC	Close W/Order and Ensure Travelers attached Inspect Level 21 Travelers: D3204-041 D3204-1 D3204-7	DL	05/07/17	3

Rev	Date	Change	Revised By	Approved
A	04.04.14	New issue	KJ/RF	
B	04.06.09	Added Travelers	KJ/RF	

**RELEASED**

RF 04.06.21

DART AEROSPACE LTD		Work Order:	23190
Description: Arm		Part Number:	D3204-3
Inspection Dwg: D3204	Rev: A	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.00	+/-0.030					
5.25	+/-0.030					
0.776	+/-0.010					
Ø0.760	+0.005/-0.000					
0.080	+/-0.010					
R0.50	+/-0.010					
2.373	+/-0.010					
0.750	+/-0.010					
R0.380	+/-0.010					
Ø0.375	+0.001/-0.000					
0.300	+/-0.010					
Same as 23524 w/o						

Measured by: SD	Audited by: E	Prototype Approval:	N/A
Date: 05.07.07	Date: 05.07.08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue (P/O D3204-041)	KJ/JLM	

RELEASED  
05.02.22







<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23190
<b>Description:</b> Bushing		<b>Part Number:</b>	D3204-7
<b>Dwg:</b> D3204 Rev. A page 2		<b>Qty:</b>	4
<b>Ref:</b>		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler <b>Dwg not required</b>	AP	05/05/09	4
2	MC	Turn D3204-7 bushing as per Folio FA355 and Dwg D3204 Material: AISI 303 SS Ø0.50" (M303R0.500) <b>Identify for D3204-7</b> Batch: _____			
3	QC2	Inspect parts as they come off the CNC machine <b>Identify as D3204-7</b>			
4	MC	Deburr			
5	QC8	Second check			
6	MC	Go to D3204-041 for assembly			

Rev	Date	Change	Revised By	Approved
A	04.04.14	New issue	KJ/RF	
B	04.06.09	Change Step 6; remove Steps 7 & 8	KJ/RF RF	RF

**RELEASED**

RF 04.06.21

5/22

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	23190
<b>Description:</b> Tube		<b>Part Number:</b>	D3204-1
<b>Dwg:</b> D3204 Rev. A page 2		<b>Qty:</b>	4
<b>Ref:</b>		Page 1 of 1	

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	AP	05/05/09	4
2	MC	Turn D3204-1 tube as per Folio FA356 and Dwg D3204 Material: 6061-T6/-T62 (QQ-A-200/8) Ø0.750" x 0.125" wall (M6061T6T0.750W.125) Identify for D3204-1	J.G.	05/06/06	5
3	QC2	Inspect parts as they come off the CNC machine Identify as D3204-1	J.G.	05/06/06	5
4	MC	Deburr	J.G.	05/06/06	5
5	QC8	Second check	RF	05.06.06	5
6	MC	Go to D3204-041 for welding	GPL	05.07.12	5

Rev	Date	Change	Revised By	Approved
A	04.04.14	New issue	KJ/RF	
B	04.06.09	Change Step 6; remove Steps 7 & 8	KJ/RF RF	RF

RELEASED

RF 04.06.21

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